

Date: Thursday, 3/13/2008 10:19:33 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 37925B					
Estimate Number	: 10354					
P.O. Number	:		Part Number	: D2322		
This Issue	: 3/13/2008	S.O. No. :	Drawing Number	: D2322 REV C		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type	Drawing Revision	: C		
Previous Run	: 37452B		Material	:		
Written By	:		Due Date	: 3/28/2008	Qty:	10 Um: Each
Checked & Approved By	:					
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
Comment: Qty.: 0.2132 sf(s)/Unit Total : 2.1315 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2322 Batch: <u>107461</u> <u>R</u> <u>8-3-26</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2322 Dwg Rev: <u>C</u> <u>RB 8-3-26</u> Prog Rev: <u>C</u> <u>(10)</u>		
2-Deburr if necessary <u>R 8-3-26</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>RB 8-3-26</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>5</u> <u>08/03/26</u> <u>(10)</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form as per Dwg D2322 <u>SB 08/03/26</u> <u>(10)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>S 08/03/26 (10)</i>
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		<i>BK 08-03-26</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>FZ 08/03/26 (10)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>PAT</i>		<i>F-8/3/27 (10)</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>D08103127 (10)</i>
Job Completion		 <i>mf 08-03-27.</i>
<i>W</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37925B
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HR
Date:	8-3-26

Audited by:	<u>a</u>
Date:	08/03/26

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM <i>[initials]</i>	<i>[initials]</i>

DART**RELEASED**

18.10.08 DS

0103.15 90

~~DESIGN OK BUT CHECK WITH
T3 BEFORE ANNUAL FRACTURE~~

OK GKP JH/MQ

DESIGN B.W	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>JW</i>	DRAWING NO. D2322
DATE 98.09.29	TITLE STEP SPACER	REV. C SHEET 1 OF 1 SCALE 1:2
A 98.09.29	94.10.14 NEW ISSUE	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001
C 98.09.29		

